

Date: Thursday, 11/09/2008 10:41:59 AM
 User: Julie Lecocq

Process Sheet

| | | | | | |
|-----------------------|--|--|------------------|-----------------------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : SADDLE, OUTBOARD, RH, 206 | |
| Job Number | : 41975 | | Part Number | : D26652 | |
| Estimate Number | : 10523 | | Drawing Number | : D2665 REV. D | |
| P.O. Number | : | | Project Number | : N/A | |
| This Issue | : 11/09/2008 S.O. No. : | | Drawing Revision | : D | |
| Prsh Rev. | : NC | | Material | : | |
| First Issue | : / / Type : MACHINED PARTS | | Due Date | : 10/10/2008 Qty: 10 | |
| Previous Run | : 38750 | | Um: | Each | |
| Written By | : | | | | |
| Checked & Approved By | : JUL008.9.11 | | | | |
| Comment | : Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC Est Rev:D As per Rev D 07-03-19 JLM | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|--|--------------------------|
| 1.0 | D6101003 | Saddle Billet, 7075 | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 2X6.25X7.875 Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length | B 33792 X 10 88/08/09/25 |
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 | |
| | | Comment: HAAS CNC VERTICAL MACHINING #1 1- Program batch number 2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet 4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet 5- Deburr | PTO 88/08/09/25 |
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE | |
| | | Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet | 88/08/09/26 |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | 88/08/09/26 |
| 5.0 | QC8 | SECOND CHECK | |
| | | Comment: SECOND CHECK | 88/08/09/27 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D2465-2 PAR #: Fault Category: NCR: Yes No DQA: Date: 08/09/30

Resolution: Disposition: QA: N/C Closed: Date: _____

| NCR: 41975 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------------|------|---|---------------------------------|--|----------------|---------------------------|---------------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 08/09/26 | 2.0 | First part run at zero and figure that the flange thickness was too thick. I lower the tools but forgot To lift all the other tools | GP 08.09.26 JW QSI 042 | DEPTH OF CUT IS 0.127". So thickness is 0.108" MIN, So PART ACCEPTABLE . | SS 08/09/26 | S 08/09/30 | GP 08.09.26 JW QSI 042 | S 08/09/30 |
| | | So the dimension of .110(L) ± .010" was .127 . R.C operator error | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 11/09/2008 10:41:59 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 41975

Part Number: D26652

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(13)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Fx 08/09/29

7.0 POWDER COATING

POWDER COATING



(10x)

M109152

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

8:50

OVEN TEMPERATURE:

320°

FINISH TIME:

9:20

M.F. 08/09/29

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-09-29

(10)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

L. J. 09/29

(10)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/30 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M.F. 08-09-30

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|---|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 41975 |
| Description: 206 Saddle, Outboard, Right side | Part Number: | D2665-2 |
| Inspection Dwg: D2665 Rev. D | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|-----|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.100 | 0.140 | | .112 | .113 | .113 | .113 | | |
| B | 0.100 | 0.140 | | .120 | .127 | .121 | .121 | | |
| C | 1.125 | 1.145 | | 1.133 | 1.133 | 1.133 | 1.133 | | |
| D | 0.615 | 0.685 | | .677 | .677 | .677 | .677 | | |
| E | 0.240 | 0.260 | | .254 | .254 | .253 | .253 | | |
| F | 1.313 | 1.343 | | 1.323 | 1.325 | 1.325 | 1.325 | | |
| G | 0.210 | 0.230 | | .220 | .222 | .222 | .221 | | |
| H | 0.100 | 0.180 | | .140 | .140 | .140 | .140 | | |
| I | 2.470 | 2.510 | | 2.490 | 2.490 | 2.490 | 2.490 | | |
| J | 1.565 | 1.585 | | 1.573 | 1.573 | 1.573 | 1.573 | | |
| K | 0.235 | 0.240 | | .239 | .239 | .239 | .239 | | |
| L | 0.100 | 0.120 | | .127 | .127 | .117 | .117 | | |
| M | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | 1.000 | | |
| N | 0.510 | 0.515 | | .510 | .510 | .510 | .510 | | |
| O | 5.990 | 6.010 | | 6.003 | 6.003 | 6.000 | 6.000 | | |
| P | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | | |
| Q | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| R | 0.313 | 0.318 | | .318 | .318 | .318 | .318 | | |
| S | 0.315 | 0.322 | | .315 | .320 | .320 | .320 | | |
| T | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| U | 1.357 | 1.367 | | 1.362 | 1.362 | 1.362 | 1.362 | | |
| V | 0.787 | 0.807 | | .800 | .800 | .800 | .800 | | |
| W | 0.540 | 0.560 | | .550 | .550 | .550 | .550 | | |
| X | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | | |
| Y | 0.257 | 0.262 | | .258 | .258 | .258 | .258 | | |
| Z | 0.912 | 0.932 | | .921 | .921 | .921 | .921 | | |
| AA | 0.490 | 0.510 | | .500 | .495 | .497 | .497 | | |
| AB | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |

Accept/Reject

| | | | |
|--------------|-----------|-------------|------------|
| Measured by: | <i>SP</i> | Audited by: | <i>AKL</i> |
| Date: | 08/09/25 | Date: | 08/09/27 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------------|------------|
| A | | New Issue | RF | |
| B | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF | |
| C | 99.11.10 | Added Dim. R-T | RF | |
| D | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686 | KJ/RF | |
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM <i>SP</i> | <i>JLM</i> |

DART AEROSPACE LTD

Work Order:

41975

Description: 206 Saddle, Outboard, Right side

Part Number:

D2665-2

Inspection Dwg: D2665 Rev. D

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | |
|-----|-------|-------|----------------|----------------------------|-------|--------|-------|-------------|
| | | | | .54 | .62 | .73 | .84 | .9 By |
| A | 0.100 | 0.140 | | .113 | .113 | .113 | .112 | .113 .113 |
| B | 0.100 | 0.140 | | .120 | .120 | .120 | .121 | .124 .125 |
| C | 1.125 | 1.145 | | 1.133 | 1.135 | 1.138 | 1.135 | 1.135 1.135 |
| D | 0.615 | 0.685 | | .670 | .670 | .670 | .674 | .675 .673 |
| E | 0.240 | 0.260 | | .252 | .252 | .252 | .251 | .251 .251 |
| F | 1.313 | 1.343 | | 1.325 | 1.325 | 1.325 | 1.325 | 1.325 1.326 |
| G | 0.210 | 0.230 | | .220 | .222 | .222 | .221 | .222 .221 |
| H | 0.100 | 0.180 | | .140 | .140 | .140 | .140 | .140 .140 |
| I | 2.470 | 2.510 | | 2.490 | 2.490 | 2.490 | 2.490 | 2.490 2.496 |
| J | 1.565 | 1.585 | | 1.578 | 1.578 | 1.5783 | 1.572 | 1.572 1.573 |
| K | 0.235 | 0.240 | | .239 | .239 | .239 | .238 | .238 .237 |
| L | 0.100 | 0.120 | | .112 | .112 | .112 | .110 | .110 .110 |
| M | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | 1.000 | 1.000 1.000 |
| N | 0.510 | 0.515 | | .510 | .510 | .510 | .512 | .511 .512 |
| O | 5.990 | 6.010 | | 6.000 | 6.000 | 6.000 | 6.000 | 6.000 6.000 |
| P | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 1.250 |
| Q | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 2.500 |
| R | 0.313 | 0.318 | | .318 | .318 | .318 | .318 | .318 .318 |
| S | 0.315 | 0.322 | | .320 | .320 | .320 | .320 | .320 .320 |
| T | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 2.500 |
| U | 1.357 | 1.367 | | 1.360 | 1.360 | 1.360 | 1.361 | 1.360 1.366 |
| V | 0.787 | 0.807 | | .800 | .800 | .800 | .796 | .796 .796 |
| W | 0.540 | 0.560 | | .550 | .550 | .550 | .545 | .546 .545 |
| X | 1.674 | 1.684 | | 1.679 | 1.678 | 1.678 | 1.678 | 1.679 1.679 |
| Y | 0.257 | 0.262 | | .258 | .258 | .258 | .259 | .259 .259 |
| Z | 0.912 | 0.932 | | .921 | .921 | .921 | .925 | .925 .925 |
| AA | 0.490 | 0.510 | | .500 | .500 | .500 | .502 | .501 .503 |
| AB | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | .188 .188 |
| AC | | | | | | | | |
| AD | | | | | | | | |
| AE | | | | | | | | |
| AF | | | | | | | | |

Accept/Reject

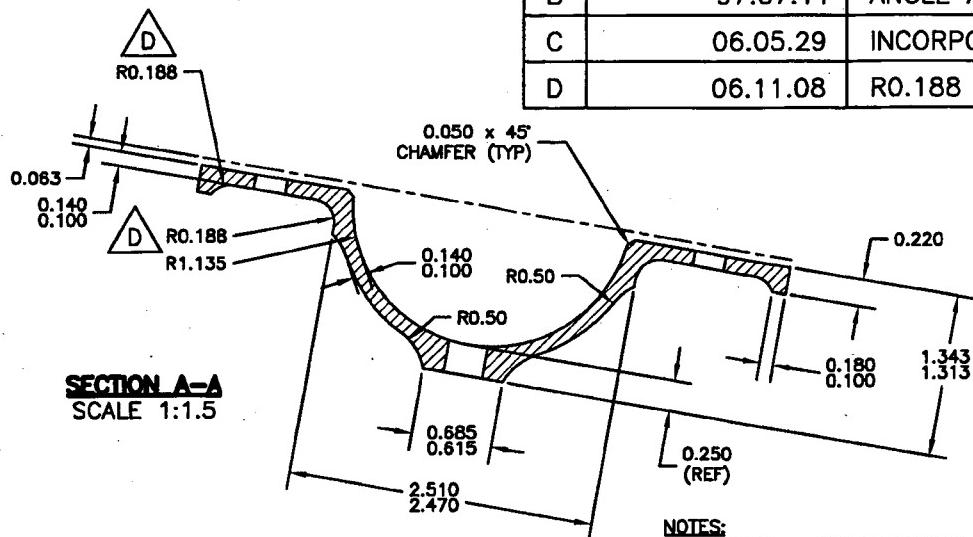
| | |
|--------------|-----------|
| Measured by: | <i>JL</i> |
| Date: | 09/09/20 |

| | |
|-------------|------------|
| Audited by: | <i>JML</i> |
| Date: | 08/10/22 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------------|-----------|
| A | | New Issue | RF | |
| B | 99.04.19 | Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A | RF | |
| C | 99.11.10 | Added Dim. R-T | RF | |
| D | 02.12.12 | Reformat; Added Dim. U-W & DT8683, DT8686 | KJ/RF | |
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM <i>JL</i> | <i>JL</i> |

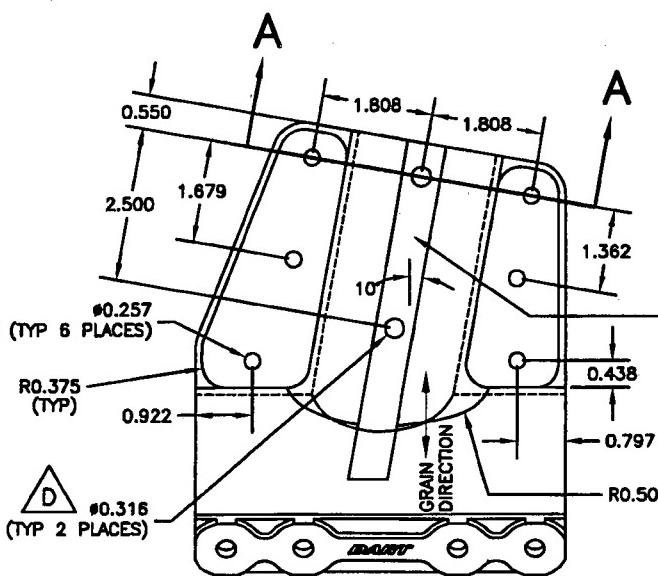
DART

| | | |
|------------------|----------------|--|
| DESIGN # | DRAWN BY CB | DART AEROSPACE USA, INC. PORT HADLOCK, WA |
| CHECKED PH | APPROVED CH | DRAWING NO. D2665 |
| DATE 06.11.08 | | REV. D SHEET 1 OF 1 SCALE 1:3 |
| A | 97.03.25 | NEW ISSUE |
| B | 97.07.11 | ANGLE AND NOTES ADDED |
| C | 06.05.29 | INCORPORATE DEO 9122, 9102, 9095 |
| D | 06.11.08 | R0.188 WAS R0.30; Ø0.316 WAS Ø0.313 |



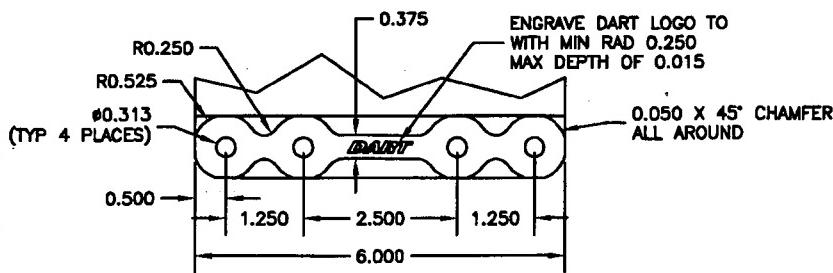
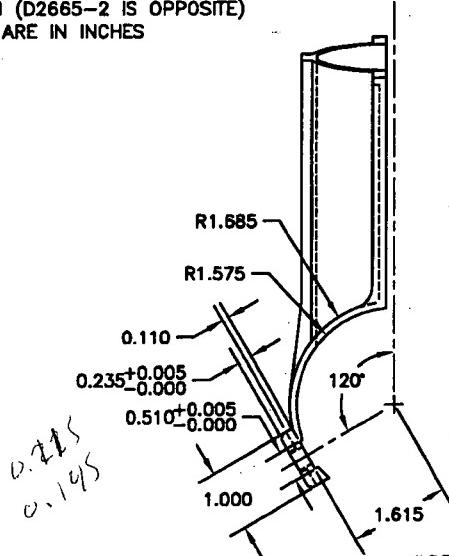
RELEASED

07.02.12



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

D2665-1 SADDLE FWD OUTSIDE HIGH

AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 41975

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